# Work Order ID 57399

*April 6, 2010 11:46:16 AM*

**Item ID:** D350-591-214 **Accept**

**Setup** Start / Stop

**Revision ID:**

**Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Start Qty:** 4.00

**Required Date:** 4/14/10 **Req'd Qty:** 4.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** Start / Stop

**Approvals:** **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

**QC:** ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D3078 | A |
| DSI 9472 | A |

100 — DOCUMENT CONTROL — 0.00

DC

Document Control

**Memo** 0.00

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

110 — Large Fab — 0.00

Large Fab

Large Fab

**Memo** 0.00

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

# Work Order ID 57399

*April 6, 2010 11:46:17 AM*



**Item ID:** D350-591-214 **Accept** **Setup Start**

**Revision ID:**

**Item Name:** Heli-Access-Step, Short RH **Stop**

**Start Date:** 4/06/10 **Start Qty:** 4.00 **Cust Item ID:**

**Required Date:** 4/14/10 **Req'd Qty:** 4.00 **Customer:**

**Reference:**

**Run Start**

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120<br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br>**Memo** | 0.00<br>0.00 | S 10/04/08 | | | 4 | | | |
| 130<br>Large Fab<br>Large Fab | Large Fab<br>**Memo**<br>1-Bevel end for welding FWD ONLY<br>2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078<br>A/RAluminum Rod M11311<br>3-Grind End Plate flush M114242 | 0.00<br>0.00 | 10.04.08 | | | 4 | 0 | | |
| 140<br>QC<br>Quality Control | QC9- Inspect visual per QSI004- Fusion Welds<br>**Memo** | 0.00<br>0.00 | | | | 4 | PD 10.04.09 | | |

# Work Order ID 57399

*April 6, 2010 11:46:17 AM*

**Item ID:** D350-591-214 **Accept**

**Revision ID:**

**Item Name:** Heli-Access-Step, Short RH

**Setup** Start / Stop

**Start Date:** 4/06/10 **Start Qty:** 4.00

**Required Date:** 4/14/10 **Req'd Qty:** 4.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** Start / Stop

**Approvals:** **Process Plan:** ____________ **Date:** __________ **Tooling:** __________ **Date:** __________

**QC:** ______________ **Date:** __________ **SPC (Y/N):** __________ **Date:** __________

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 150<br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br>**Memo** | 0.00<br>0.00 S 10/04/09 | | | | X4 RH | | | |
| 160<br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br>**Memo** | 0.00<br>0.00 10-04-13 | | | | 4 | 0 | | |
| 170<br>QC<br>Quality Control | QC3- Inspect Part Finish<br>**Memo** | 0.00<br>0.00 Mr 10/04/13 | | | | 4X RH | | | |

# Work Order ID 57399

*April 6, 2010 11:46:21 AM*



**Item ID:** D350-591-214 **Accept** **Setup** **Start** **Stop**

**Revision ID:**

**Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Start Qty:** 4.00 **Cust Item ID:**

**Required Date:** 4/14/10 **Req'd Qty:** 4.00 **Customer:**

**Reference:**

**Run** **Start** **Stop**

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 200 | | 0.00 | | | | | | | |
| Large Fab<br>Large Fab | Large Fab | | | | | 4 | Ø | | |
| | **Memo**<br>1- Rivet Leg Assembly as per Dwg D3078 *[initials]*<br>2-Bevel Aft end for welding *[initials]*<br>3-Inspect for foreign object as per QSI 024 *[initials]*<br>4-Weld Aft End Plate as per QSI 004 & Dwg D3078 *[initials]* *[initials] 10·04·14*<br>A/R Aluminum Rod *M11/311*<br>5-Grind End Plate flush *[initials] grind (1)*<br>*JAD grind (3)* | 0.00 | | | | | | | |
| 210<br>QC<br>Quality Control | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | (4) | *PD 10.04.15* | | |
| | **Memo** | 0.00 | | | | | | | |

# Work Order ID 57399

*April 6, 2010 11:46:21 AM*

**Item ID:** D350-591-214 **Accept**

**Revision ID:**

**Item Name:** Heli-Access-Step, Short RH

**Setup** Start / Stop

**Start Date:** 4/06/10 **Start Qty:** 4.00

**Required Date:** 4/14/10 **Req'd Qty:** 4.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** Start / Stop

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 220<br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br><br>**Memo** | 0.00 S 10/04/15<br>0.00 | | | | +4 RH | | | |
| 230<br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>**Memo** | 0.00<br>0.00 | | | | 4 | | BR 10-4-15 | |
| 240<br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br>M114207<br>**Memo**<br>START TIME: 1:30pm<br>OVEN TEMPERATURE: 320°F<br>FINISH TIME: 2:00pm | 0.00<br>0.00 JM 10/04/15 | | | | 4 | Ø | | |

# Work Order ID 57399

*April 6, 2010 11:46:27 AM*



**Item ID:** D350-591-214 **Accept** **Setup Start**

**Revision ID:** **Stop**

**Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Start Qty:** 4.00 **Cust Item ID:**

**Required Date:** 4/14/10 **Req'd Qty:** 4.00 **Customer:**

**Reference:**

**Run Start**

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Stop**

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 250 HandFinish Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch M113545 **Memo** | 0.00 0.00 | | | | 4. | | BR 10-4-15 | |
| 260 QC Quality Control | QC3- Inspect Part Finish **Memo** | 0.00 0.00 Sidoy 20 | | | | x4 RH | | | |
| 270 Packaging Packaging | Pick Kit **Memo** | 0.00 0.00 | | | | 10-4-19 | | 40 | |

# Work Order ID 57399

*April 6, 2010 11:46:27 AM*



**Item ID:** D350-591-214

**Accept**

**Setup** **Start**

**Stop**

**Revision ID:**

**Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Start Qty:** 4.00

**Required Date:** 4/14/10 **Req'd Qty:** 4.00

**Cust Item ID:**

**Customer:**

**Reference:**

**Run** **Start**

**Stop**

**Approvals:** **Process Plan:** ______________ **Date:** __________ **Tooling:** ____________ **Date:** __________

**QC:** ____________________ **Date:** __________ **SPC (Y/N):** ____________ **Date:** __________

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 280<br>QC<br>Quality Control | QC4- 100% Inspect kits for completeness<br>**Memo**<br>I Part Rec Labels on. S 06/04/20 | 0.00<br>0.00<br>S 06/04/20 | | | | x4<br>RH | | | |
| 290<br>Packaging<br>Packaging | Packaging<br>**Memo**<br>Identify and pack for shipping as per PPP D350-591-214<br>Location: 8D<br>PPP Rev: E | 0.00<br>0.00 | | | | 16-4-20 (42) | | | |
| 300<br>QC<br>Quality Control | QC21- Final Inspection - Work Order Release<br>**Memo** | 0.00<br>0.00 | | | | | | 10/04/21 | |

MF
10-4-21

# Picklist Print

*April 6, 2010 11:45:56 AM*



**Work Order ID:** 57399

**Parent Item:** D350-591-214

**Parent Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Required Date:** 4/14/10

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:** IPP Rev:B□05.10.14□Modified step 10□KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D3065-041<br>Step Leg Assembly Hi | | Manufactured | No | | | | Each | 14.0000 | 4.0000 | | 10.04.14 | |
| D3066-1<br>Spacer | | Manufactured | No | | | | Each | 44.0000 | 8.0000 | | 10.04.14 | |
| MS20600-AD4W4<br>Rivets | | Purchased | No | | | | Each | 979.0000 | 64.0000 | | 10.04.14 | |

D3065-041 locations:

| Warehouse Location | Loc Qty | Loc Code | Qty |
|---|---|---|---|
| Main Warehouse | | | |
| WA | 14 | | |
| 55450 | 14 | | 4 |

D3066-1 locations:

| Warehouse Location | Loc Qty | Loc Code | Qty |
|---|---|---|---|
| Main Warehouse | | | |
| WA | 44 | | |
| 56752 | 44 | | 8 |

MS20600-AD4W4 locations:

| Warehouse Location | Loc Qty | Loc Code | Qty |
|---|---|---|---|
| Main Warehouse | | | |
| ST321 | 979 | | |
| 113368 | 479 | | 64 |
| 114181 | 500 | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng / Prod Mgr | Approval<br>QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**Resolution:** ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC<br>Section A | Corrective Action Section B | | | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
| | | | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

# Picklist Print

*April 6, 2010 11:45:56 AM*

**Work Order ID:** 57399

**Parent Item:** D350-591-214

**Parent Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Required Date:** 4/14/10

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:**
IPP Rev:B□05.10.14□Modified step 10□KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D2622-120C<br>Step Extrusion | | Manufactured | No | | | 110 | Each | 99.0000 | 2.0000 | | 10.04.08 | |
| D3063-1<br>Support | | Manufactured | No | | | 130 | Each | 16.0000 | 4.0000 | | 10.04.08 | |
| D3067-1<br>End Plate | | Manufactured | No | | | 130 | Each | 29.0000 | 4.0000 | | 10.04.08 | |

D2622-120C:

| Warehouse Location | Loc Qty | Loc Code | Qty |
|---|---|---|---|
| Main Warehouse | | | |
| WA | 99 | | |
| 55214 | 99 | | 4 |

D3063-1:

| Warehouse Location | Loc Qty | Loc Code | Qty |
|---|---|---|---|
| Main Warehouse | | | |
| WA | 16 | | |
| 51237 | 16 | | 4 |

D3067-1:

| Warehouse Location | Loc Qty | Loc Code | Qty |
|---|---|---|---|
| Main Warehouse | | | |
| WA | 29 | | |
| 57011 | 29 | | 4 |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

# Picklist Print

*April 6, 2010 11:45:57 AM*

**Work Order ID:** 57399

**Parent Item:** D350-591-214

**Parent Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Required Date:** 4/14/10

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:** IPP Rev:B05.10.14Modified step 10KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D3067-1 End Plate | | Manufactured | No | | | 200 | Each | 29.0000 | 4.0000 | | 10.04.14 | |
| AN3-35A +2 Bolt | | Purchased | No | | | 270 | Each | 56.0000 | 8.0000 | 4 | 10-4-19 | |
| AN4-11A x2 Bolt | | Purchased | No | | | 270 | Each | 435.0000 | 24.0000 | 8 | 10-4-19 (40) | |

D3067-1 locations:

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| WA | 29 | |
| 57011 | 29 | |

AN3-35A locations:

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| ST353 | 56 | |
| 112314 | 56 | |

AN4-11A locations:

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| ST357 | 435 | |
| 110382 | 435 | 24 |

6 +4

5 +4

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| W/O: | WORK ORDER CHANGES | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*April 6, 2010 11:45:57 AM*

**Work Order ID:** 57399

**Parent Item:** D350-591-214

**Parent Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Required Date:** 4/14/10

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:** IPP Rev:B□05.10.14□Modified step 10□KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| AN4-13A x4 Bolt | | Purchased | No | | | 270 | Each | 47.0000 | 16.0000 | M114330 | 10-4-19 | |

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| ST357 | 47 | |
| 114181 | 40 | |
| 4828 | 7 | |

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| AN4-16A x4 Bolt | | Purchased | No | | | 270 | Each | 95.0000 | 16.0000 | [illegible] | 10-4-19 | |

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| ST358 | 95 | |
| 112969 | 27 | |
| 114129 | 68 | |

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| AN960JD10 (NAS1149D0363) x4 Washer | | Purchased | No | | | 270 | Each | 0.0000 | 16.0000 | M114292 | 10-4-19 | |
| AN960JD416 (NAS1149D0463) x12 Washer | | Purchased | No | | | 270 | Each | 0.0000 | 48.0000 | M113706 | 10-4-19 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng / Prod Mgr | Approval<br>QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ________ Fault Category: ____________ NCR: Yes No DQA: ______ Date: __________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: __________ Date: __________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC<br>Section A | Corrective Action Section B | | | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
| | | | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

**Work Order ID:** 57399

**Parent Item:** D350-591-214

**Parent Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Required Date:** 4/14/10

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:** IPP Rev:B□05.10.14□Modified step 10□KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D2230-1 x2<br>Lug | | Manufactured | No | | | 270 | Each | 75.0000 | 8.0000 | | 10-4-19 | SP |
| D2230-3 x2<br>Lug | | Manufactured | No | | | 270 | Each | 153.0000 | 8.0000 | | 10-4-19 | SP |
| D2732<br>Rubber Extrusion | | Manufactured | No | | | 270 | f | 493.0000 | 4.0000 | | 10-4-19 (40) | SP |

D2230-1:

| Warehouse Location | Loc Qty | Loc Code | |
|---|---|---|---|
| Main Warehouse | | | |
| ST476 | 75 | | |
| 54755 | 75 | | 8 |

D2230-3:

| Warehouse Location | Loc Qty | Loc Code | |
|---|---|---|---|
| Main Warehouse | | | |
| ST476 | 153 | | |
| 56855 | 153 | | 8 |

D2732:

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| ST412 | 493 | |
| 43118 | 1 | |
| 56516 | 492 | |

Cut 3.00" long, qty 4 → measured S 10/04/20

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

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# Picklist Print

*April 6, 2010 11:45:58 AM*

**Work Order ID:** 57399

**Parent Item:** D350-591-214

**Parent Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Required Date:** 4/14/10

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:** IPP Rev:B□05.10.14□Modified step 10□KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D2856-400<br>Abraison Strip | | Manufactured | No | | | 270 | f | 235.5600 | 2.4000 | | 10-4-19 | |

| Warehouse Location | Loc Qty | Loc Code | |
|---|---|---|---|
| Main Warehouse | | | |
| ST403 | 235.56 | | |
| ~~50593~~ | -1.2 | | |
| 52563 | 20.76 | | |
| 56626 | 216 | | |

8 +4

cut 7.20" long, qty 1 → Measured 7.20

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| MS21042L3<br>Nut | | Purchased | No | | | 270 | Each | 1,377.000 | 8.0000 | | 10-4-19 | (4U) |

| Warehouse Location | Loc Qty | Loc Code | |
|---|---|---|---|
| Main Warehouse | | | |
| ST300 | 1377 | | |
| ~~113537~~ | 393 | | 8 |
| 113644 | 984 | | |

5 +4

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*April 6, 2010 11:45:59 AM*

**Work Order ID:** 57399

**Parent Item:** D350-591-214

**Parent Item Name:** Heli-Access-Step, Short RH

**Start Date:** 4/06/10 **Required Date:** 4/14/10

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:** IPP Rev:B□05.10.14□Modified step 10□KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

| Component Item ID/ | Replacement | Mfg/ | Bin | Primary | Last | Route | Unit of | Qty on | Remaining | Qty | Date | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| MS21042L4 x6 Nut | | Purchased | No | | | 270 | Each | 1,590.000 | 24.0000 | | 10-4-19 | |

5 4

| Warehouse Location | Loc Qty | Loc Code | |
|---|---|---|---|
| Main Warehouse | | | |
| ST139 | 2 | | |
| 111827 | 2 | | |
| Main Warehouse | | | |
| ST300 | 1588 | | |
| 113422 | 580 | | |
| 114108 | 1000 | | 24 |
| 9063 | 8 | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**Resolution:** ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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**NOTE:** Date & initial all entries

| DESIGN | DRAWN BY | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| CHECKED | APPROVED | DRAWING NO. D3078 REV. A SHEET 1 OF 2 |
| DATE 02.09.11 | | TITLE STEP ASSEMBLY, HI SHORT SCALE NTS |
| A | 02.09.11 | NEW ISSUE |

DART

QA COPY ISSUED

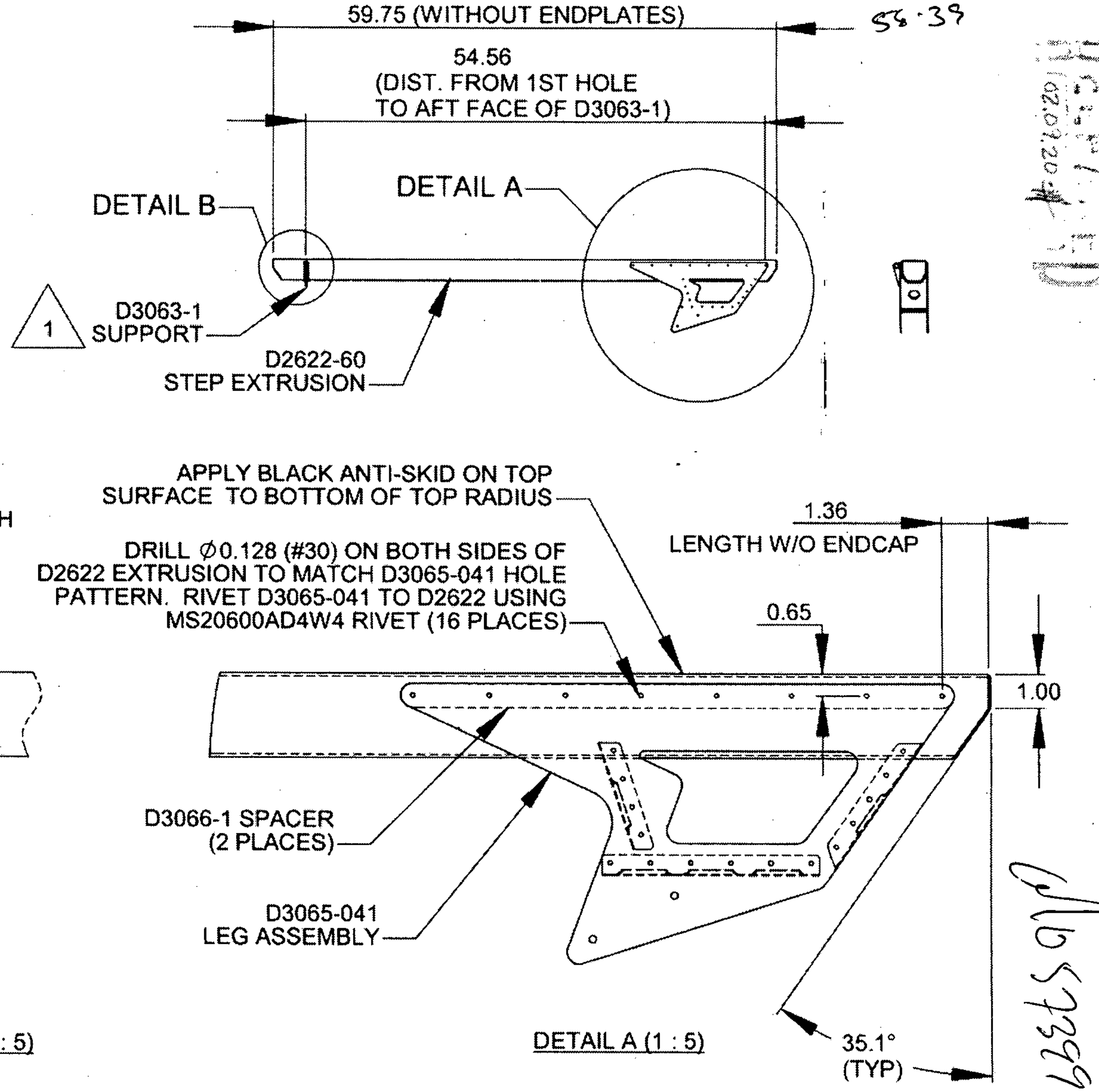
RELEASED 02.01.20

W/O 57399

| Part No. | Description | QTY -041 | QTY -042 |
|---|---|---|---|
| **D3078-041** | **Step Assembly, High Short (LH)** | **X** | |
| **D3078-042** | **Step Assembly, High Short (RH)** | | **X** |
| | | | |
| D2622-60 | STEP EXTRUSION | 1 | 1 |
| D3063-1 | SUPPORT | 1 | 1 |
| D3065-041 | LEG ASSEMBLY | 1 | 1 |
| D3066-1 | SPACER | 2 | 2 |
| D3067-1 | END PLATE | 2 | 2 |
| | | | |
| MS20600AD4W4 | RIVET | 16 | 16 |
| | | | |

**GENERAL NOTES:**

1) –041 SHOWN, FOR –042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.




**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

| DESIGN | DRAWN BY |
|---|---|
| CHECKED | APPROVED |
| DATE 02.09.11 | |

DRAWING NO. D3078
TITLE STEP ASSEMBLY, HI SHORT
REV. A
SHEET 2 OF 2
SCALE 1:20

| Qty -211 | Qty -212 | Qty -213 | Qty -214 | Qty -215 | Qty -216 | Qty -311 | Qty -312 | Part Number | Description |
|---|---|---|---|---|---|---|---|---|---|
| X | | | | | | | | D350-591-211 | ***Heli-Access-Step***™, Long Step – High Skid, LH |
| | X | | | | | | | D350-591-212 | ***Heli-Access-Step***™, Long Step – High Skid, RH |
| | | X | | | | | | D350-591-213 | ***Heli-Access-Step***™, Short Step – High Skid, LH |
| | | | X | | | | | D350-591-214 | ***Heli-Access-Step***™, Short Step – High Skid, RH |
| | | | | X | | | | D350-591-215 | ***Heli-Access-Step***™, Short Step – Low Skid, LH |
| | | | | | X | | | D350-591-216 | ***Heli-Access-Step***™, Short Step – Low Skid, RH |
| | | | | | | X | | D350-591-311 | ***Heli-Access-Step***™, Long Step – High Skid, LH |
| | | | | | | | X | D350-591-312 | ***Heli-Access-Step***™, Long Step – High Skid, RH |
| | | | | | | | | | |
| 1 | | | | | | | | D3070-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | 1 | | | | | | | D3070-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| | | 1 | | | | | | D3078-041 | STEP ASSEMBLY (HIGH-SHORT, LH) |
| | | | 1 | | | | | D3078-042 | STEP ASSEMBLY (HIGH-SHORT, RH) |
| | | | | 1 | | | | D3168-041 | STEP ASSEMBLY (LOW-SHORT, LH) |
| | | | | | 1 | | | D3168-042 | STEP ASSEMBLY (LOW-SHORT, RH) |
| | | | | | | 1 | | D3272-041 | STEP ASSEMBLY (HIGH-LONG, LH) |
| | | | | | | | 1 | D3272-042 | STEP ASSEMBLY (HIGH-LONG, RH) |
| 4 | 4 | | | | | | | D2182B035 | RUBBER CUSHION |
| | | 2 | 2 | 2 | 2 | | | D2230-1 | MOUNTING LUG |
| | | 2 | 2 | 2 | 2 | 4 | 4 | D2230-3 | MOUNTING LUG |
| 8 | 8 | | | | | | | D2274 | RADIUS BLOCK |
| | | | | | | 2 | 2 | D2618 | BUSHING |
| 4 | 4 | 4 | 4 | 4 | 4 | | | D2732-030 | CUSHION |
| 2 | 2 | 1 | 1 | 1 | 1 | 2 | 2 | D2856-400-720 | ABRASION STRIP |
| 2 | 2 | | | | | | | D3064-1 | CLAMP |
| 1 | 1 | | | | | | | D3079-041 | SUPPORT ASSEMBLY |
| 4 | 4 | | | | | | | D3080-1 | CLAMP |
| | | | | | | 2 | 2 | D3235-1 | MOUNTING LUG |
| | | | | | | 1 | 1 | D3278-041 | SUPPORT ASSEMBLY |
| | | | | | | | | | |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | AN3-35A | BOLT |
| 10 | 10 | 2 | 2 | 2 | 2 | | | AN4-11A | BOLT |
| | | 4 | 4 | 4 | 4 | 8 | 8 | AN4-13A | BOLT |
| | | | | | | 2 | 2 | AN5-36A | BOLT |
| 4 | 4 | 4 | 4 | 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 20 | 20 | 12 | 12 | 12 | 12 | 16 | 16 | AN960JD416 | WASHER |
| | | | | | | 4 | 4 | AN960JD516 | WASHER |
| 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2 | MS21042L3 | NUT |
| 10 | 10 | 6 | 6 | 6 | 6 | 8 | 8 | MS21042L4 | NUT |
| | | | | | | 2 | 2 | MS21042L5 | NUT |
| | | | | | | 1 | 1 | *DSI 9410-011 | STEP MODIFICATION KIT |

SI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is ovided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-91-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | | | Corrective Action Section B | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

**REFERENCE ONLY** 5

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

| Qty -213 | Qty -214 | Qty -215 | Qty -216 | Part Number | Description |
|---|---|---|---|---|---|
| X | | | | D350-591-213 | ***Heli-Access-Step*** ™, Short Step – High Skid, LH |
| | X | | | D350-591-214 | ***Heli-Access-Step*** ™, Short Step – High Skid, RH |
| | | X | | D350-591-215 | ***Heli-Access-Step*** ™, Short Step – Low Skid, LH |
| | | | X | D350-591-216 | ***Heli-Access-Step*** ™, Short Step – Low Skid, RH |
| | | | | | |
| 4 | 4 | 4 | 4 | AN4-16A | BOLT |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION BRANCH
DAO # 01-O-01
APPROVED
BY: D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| A | NEW ISSUE | RF | 09.08.05 |

| | | |
|---|---|---|
| DESIGN | | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | | DRAWING NO. DSI 9472 — REV. A, SHEET 1 OF 2 |
| MFG. APPR. | N/A | |
| APPROVED | | TITLE: BOLT ADDITION — SCALE: NTS |
| DE APPR. | | |
| DATE | 09.08.05 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**Resolution:** ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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**NOTE:** Date & initial all entries